

Date: Wednesday, 3/26/2008 9:33:36 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END CAP
Job Number : 38144	
Estimate Number : 11877	
P.O. Number :	Part Number : D2208
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D2208 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 37743	Material :
Written By :	Due Date : 4/1/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JD 08.3.26</u>	
Comment : Est A 01.03.08 New Issue	
Est B 07.09.11 ecn 998 EC verified by: JLM	

Additional Product

Job-Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S063

6061-T6 .063 Sheet



45



Comment: Qty.: 0.1531 sf(s)/Unit Total : 3.0618 sf(s)

6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch 107387 IB 8-3-31

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2208

Dwg Rev: CProg Rev: CIB 8-3-31

(29)

2-Deburr if necessary

IB 8-3-31

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-3-31

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5 08/03/21 (29)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STAVEPC 8/3/31 (29)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:33:36 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 38144

Part Number: D2208

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03
AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-03-31

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

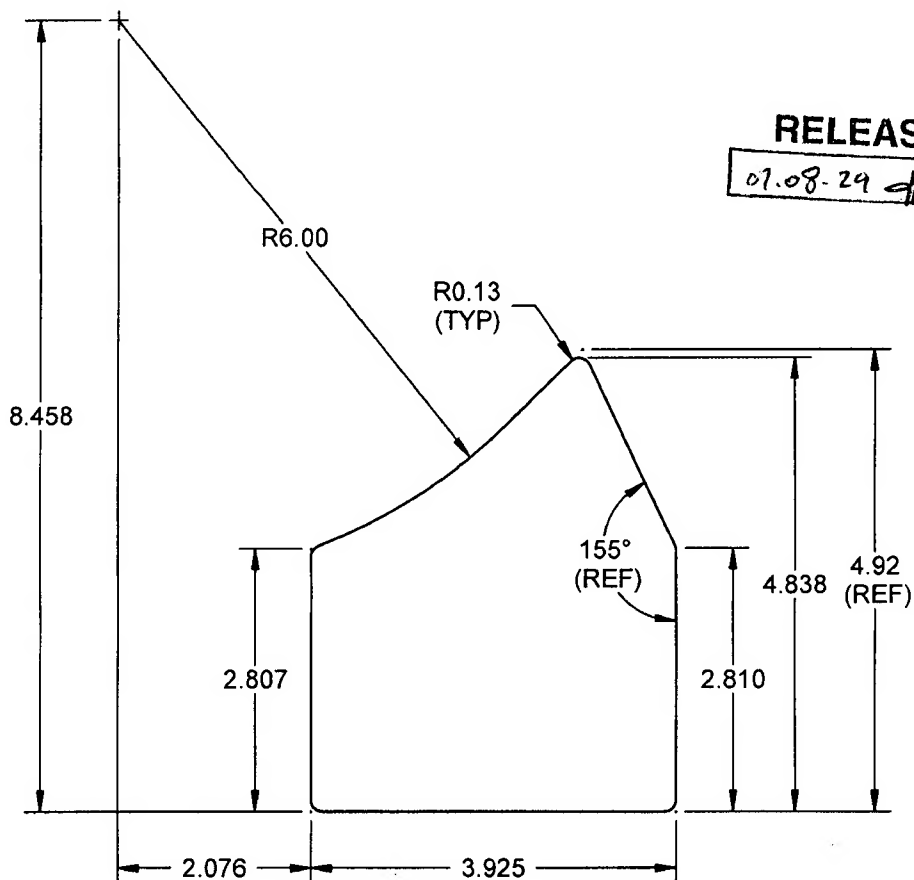
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2208	REV. C SHEET 1 OF 1
DATE 07.07.05		TITLE END CAP	SCALE 1:2
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.22	REDRAWN	
C	07.07.05	REDESIGN	



RELEASED

07.08.29 *[Signature]*

D2208 END CAP

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *38144*

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